Work Orde November-06-12				*926	349*						Page 1
tem ID:	D3262-041			Accept	*N900	040	100	)* s	etup Sta	rt *N	S1*
Revision ID: Item Name:	Canister Asser	nhly							Sto	p *\	S2*
	•	•	مکان ه مان					•		1.71	. 7/
Start Date:	11/06/12	Start Qty: 4.00	*4* *4*	3	Cust Item I	D:					•
Required Date	: 11/23/12	Req'd Qty: 4.00	*4**	3	Customer:						
Reference:				<del></del>		<del></del>	_	R	tun Sta	rt **	D4*
Approvals:	Process Pla	in:HLJ	Date: 12-11-05	Tooling:	Da	ate:	_ : :		Sto	171	R1*
, s	QC:			<b>SPC (Y/N):</b>	D:	ate:			310	" *N	R2*
Sequence ID/ Work Center I	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3262	Rev	•		.,							
100			ıminum rod Batch: 122.	324 0.00				_	P		M
*100*		Large Fab	1235	× 8				3	\$_		13.01.
Large Fab		Memo		0.00					-		13.01.
Large Fab		Weld canis	ter assembly as per Dwg D	3262 using DT8739 to al	ign fillings						
				·							•
110		QC9- Inspect visual per	QSI004- Fusion Welds	0.00							~ ^ ~
*110*								(3)	13.0	J-Q	0AS 09-
QC		Memo		0.00							9-89
Quality Control											
120		QC5- Inspect part comp	pleteness to step on W/O	0.00							2A0
*120*			· ·					(B) (	SQ26	71	045 09 
QC		Memo	•	0.00						<u> </u>	<del>- 89</del>
Quality Control		Pressure te	est as per Dwg D3262		•						

				DQA:	Date:	
NCR:	Yes /	lo	WORK ORDER NON-CONFORMANCE / UPDATE			

									QA Closed:	Date	j:	
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	PROCESS		
Part No	o				Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			Finishing	Water Jet Engineering Prod. Eng. Coor. Quality Rec/Store/Packaging Other Supplier			
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other												
Process												
Supplier								•				
Training .	$\dashv$										:	
Unapproved												
опаррточеи		<u> </u>	<u>                                     </u>		F	AULT CATE	GORY		1			
Landin	g Gear				General		<u></u> :				-	
	Bending Centre No	ot Concer	ntric to (	o/s	Bend BOM/Route Broken/Damaged	Grain Hardwa	are ion Incomplete		Ovalized Over/Under Part Incorre	<b>⊢</b>	Pressure/Forced Temperature/Cure Weld	
<u> </u>	Crushed/	Crimped		<u> </u>	Burrs	$\vdash$	tions Incomplete	/Unclear	Part Lost/Mi		Wrong Stock Pulled	
<b> </b>	Cuffs	c.mpcu.		<u> </u>	Contamination	Mainte	•	- Oncical	Part Moved	_	when got occur a mea	
<u> </u>	Heat Trea	nt			Countersink	Mislabe			Positioned V	Vrong		
-	Inspectio		Tube	<u> </u>	Cut Too Short	Misrea			Power Loss/	· ·	Other	
The state of the s	Ripples in				Drill Holes	Offset		<u> </u>	1	J- [		
	Torque W		xtrusior	, F	Drawing	<b>├</b> ──	Cal <sup>1</sup> bration					
	Turning S			-	Finish	$\vdash$	Secluence					
	Wave/Tw		e		Folio	<b>⊢</b>	D <sup>'</sup> mensions					

Quality Control

			DQA:	Date:	
ICB.	Ves / N	o WORK ORDER NON-CONFORMANCE / UPDATE			

									QA Closea:	Date	2:	
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS		
	<del></del>				Rework	]	Sk <sup>-</sup> d-tube	Crosstube		Water Jet	Engineering	ı
Part N	0				Scrap	]	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	ı
					Use-as-is	The	moforming	Finishing	Rec/Sto	re/Packaging	Other	ı
NCR N	0				Work Order Update	]	Large Fab	Composite		Supplier		ı
	<u> </u>	<u> </u>	1	D :		laniai al		-4:	C: 0	<u></u>		I
Root	5		_		ption of work order update	Initial	i	ction	Sign &	Varification	OCInchastar	
Cause	Date	Step	Qty	(	or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling										Ì		
Operator						ĺ				1	s <b>ā</b>	
Material	_											I
Setup									·			
Other			[ ]									
Process												
Supplier												
Training			1									
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Landin	ig Gear				General				-	_		
L	Bending				Bend	Grain			Ovalized		Pressure/Forced	
	Centre No	ot Concer	ntric to C	)/S	BOM/Route	Hardv	vare		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct	Weld	
	Crushed/	Crimped.			Burrs	Instru	ctions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	Cuffs				Contamination	Main	tenance		Part Moved	· —		
Ţ	Heat Trea	at			Countersink	Misla	peled		Positioned \	<b>V</b> rong		
ſ	Inspectio	n Strip in	Tube		Cut Too Short	Misre	ad		Power Loss,	/Surge	Other	
ſ	Ripples in	Bend			Drill Holes	Offse	:		_	_		•
Ī	Torque W	/aves in E	Extrusion		Drawing	Out o	f Calibration					•
·	Turning S				Finish	Out o	f Sequence					*
F	Maye/Tw	•			Folio	$\vdash$	de Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 3 November-06-12 12:29:17 PM Accept \*N900040100\* Setup Start Item ID: D3262-041 **Revision ID:** Stop Canister Assembly Item Name: \*4\* Start Qty: 4.00 **Cust Item ID: Start Date:** 11/06/12 Required Date: 11/23/12 Req'd Qty: 4.00 **Customer:** Reference: Run Start Date: Tooling: Date: Process Plan: Approvals: Stop Date:\_ SPC (Y/N): Date: Tool # Plan Tool ID Reject Reject Accept Insp. Sequence ID/ Operation Set Up/ Number Stamp Qty Qty **Run Hours** Code Description Work Center ID Identify as per dwg & Stock Location:\_ 0.00 160 \*160\* 0.00 Packaging Memo Packaging QC21- Final Inspection - Work Order Release 0.00 170 \*170\* 0.00 QC Memo Quality Control

											DQA:	Date	e:	
NCR:	⁄es	/ No				WORK ORDER NON-C	O	<b>NFORM</b>	ANCE / UPE	DATE			•	
											QA Closed:	Date	e:	
Work Orde	er:					DISPOSITION			·	AGAINST DE	PARTMENT	/PROCESS		
Part f	- No					Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet od. Eng. Coor. re/Packaging Supplier	Er	ngineering Quality Other
Root		· - · · · · · · · · · · · · · · · · · ·			Descri	ption of work order update	I	nitial	Acti	ion	Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification		QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						i								
							AUL	T CATE	GC)RY	<u> </u>				·······
Landi		<b>ear</b> Bending Centre No	ot Concer	ntric to	o/s	General Bend BOM/Route	<del></del>	Grain Hardwa	re		Ovalized Over/Unde	r tolerance	<b>-</b> -i	ssure/Forced
	$\vdash$	Cracks Crushed/0	Crimped.			Broken/Damaged Burrs		1 `	on Incomplete ions Incomplete/U	Jnclear	Part Incorre Part Lost/M	<b> </b>	Wel Wro	ld ong Stock Pulled
		Cuffs Heat Trea				Contamination Countersink		Mainte Mislabe	led		Part Moved Positioned	Wrong	_	
	-	Inspectior Ripples in	-	Tube	-	Cut Too Short Drill Holes		Misread Offset	I	L	Power Loss	/Surge	Oth	er

Out of Calibration

Out of Secuence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-06-12 12:29:16 PM

Work Order ID:

92649

Parent Item:

D3262-041

Parent Item Name:

Canister Assembly

**Start Date:** 11/06/12

Required Date: 11/23/12

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP C05.03.10Removed P/O for liquid penetrant

inspectionKJ/JLM

571 DD 10.05 10 verified EC

IPP Rev:D as per ECN10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Date Status Issued Issued
D3262-1		Manufactured	No	391	110-	)100	Each	0.0000	1	4	113.01.23
Tube <b>D3262-3</b> Cap		Manufactured	No	393	3805 =	2100	Each	6.0000	2	8	M13.01.23
С.,				Location LG B	91926=	Loc Oty	<u>Lc</u> 1 1	oc Code		4_	
				LG002 868	81 = Q	2	2 2			2	

											DQA:	Date	e:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	AANCE / UP	DATE				·
						· · · · · · · · · · · · · · · · · · ·		<u>,                                      </u>			QA Closed	: Date	e:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part I	No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other
Root					Descri	ption of work order update	Π	Initial	Act	ion	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification		QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
							AUL	LT CATE	GORY					
Landi		Gear Bending Centre No Cracks Crushed/ Cuffs Heat Trea	Crimped. at		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		<b>⊣</b> `	or Incomplete ions Incomplete/U nance led	Jnclear	Ovalized Over/Unde Part Incorre Part Lost/M Part Moved Positioned Power Loss	ect lissing l Wrong		ressure/Forced emperature/Cure /eld /rong Stock Pulled ther
		Ripples ir	Bend			Drill Holes		Offset						

Out of Calibration

Out of Secuence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

ITEM	QTY -041	P/N	DESCRIPTION	
	X	D3262-041	CANISTER ASSEMBLY	
1	1	D3262-1	TUBE	_
2	2	D3262-3	CAP	

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RETURN

ENGINEE

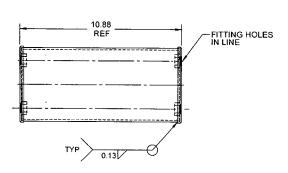
**UNCONTRO!** 

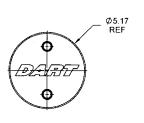
SUBJECT TO

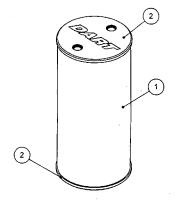
WITHOU !:

WOGA . NO 92649 MLJ

12-11-07







## **D3262-041 CANISTER ASSEMBLY**

NOTES:	
1) MATERIAL: N/A	
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1	
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3	
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED	
4) UNITS: INCHES UNLESS OTHERWISE NOTED	
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX	
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MAR	KER
7) WEIGHT: 2.51 lbs	
8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR	
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS	

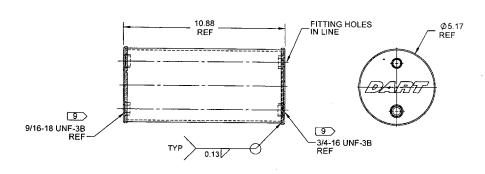
Ε	0.25 WAS 0.45 (ZNC7-4, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7-5); ADD DIMENSION (ZN B1-4, D1-5, B1-5)	RF	10.05.03
D	ADD 03262-043/-5 (ZN B5-2; B5-5); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN B2-4; C2-4) PER CAR 09-004	RF	09.12.30
С	Ø5.165 WAS Ø5.190	RF	06.08.31
В	ADD PRESSURE TESTING OPTION	MB	05.02.14
Α	NEW ISSUE	RF	04.05.06
REV.	DESCRIPTION	BY	DATE

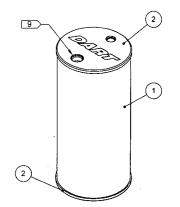
REV.		DESCRIPTION BY	DATE					
DESIGN	RF	DART AEROSPACE LTD						
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA						
CHECKED	as	DRAWING NO.	REV. E					
MFG. APPR.	all.	D3262	SHEET 1 OF 5					
APPROVED	10	TITLE	SCALE					
DE APPR.	_#_	FUEL PURGE CANISTER	NTS					
DATE 10	05 O3	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPRIENTLY, AND IS SUPPLIED ON THE DURESS CONDITION THAT.						

ITEM	QTY -043	P/N .	DESCRIPTION	
	X	D3262-043	CANISTER ASSEMBLY	
1	1	D3262-1	TUBE	
2	2	D3262-5	CAP	

92649

С





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## **D3262-043 CANISTER ASSEMBLY**

5

RELEASED 2010 -05- 057

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNILESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 2.50 lbs
8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

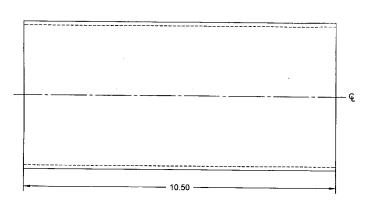
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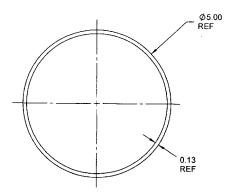
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DESIGN	RF	DART AEROSPACE LTD	
DRAWN RF		HAWKESBURY, ONTARIO, CANADA	
CHECKED	#5.	DRAWING NO.	REV. E
MFG. APPR.	91	D3262	SHEET 2 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.	-4	FUEL PURGE CANISTER	NTS
DATE 10.05.03		COPYRIGHT © 2004 BY DART AEROSPAC THIS DOCUMENT IS PRIVATE AND COMPERNITUL AND IS SUPPLIED ON THE EXPRE NOT TO BE USED FOR ANY PURPOSE OF COPIED OR COMMUNICATED TO ANY OWNER TO PROVIDE A PROPERTY OF THE PROPERTY AND PROPERTY.	SS CONDITION THAT IT IS

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**D3262-1 TUBE** 



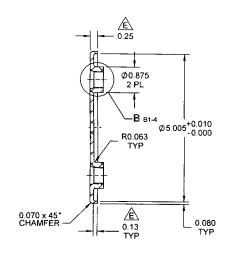
NOTES: 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6T5.000W.125 REF. DART SPEC. M6061T6T5.000W.125
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.96 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	DART AEROSPACE	TD
DRAWN	RF	HAWKESBURY, ONTARIO, CAN	
CHECKED	<b>\$</b>	DRAWING NO.	REV. E
MFG. APPR.	91	D3262	SHEET 3 OF 5
APPROVED	10	TITLE	SCALE
DE APPR.	-14	FUEL PURGE CANISTER	NTS
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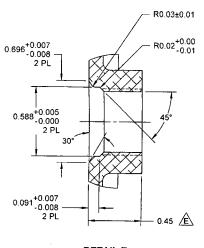
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DRILL THRU Ø0.516 (33/64 DRILL), TAP HOLE 9/16-18 UNF-3B B6-4 PER MIL-S-8879 Ø5.165 2 PL REF 1.63 3.25 REF 6



DETAIL B SCALE 2X C7-4

SECTION A-A C5-4

D3262-3 CAP

NOTES:
1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B

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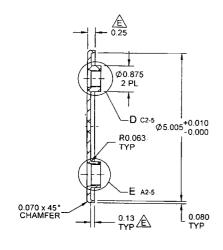
В

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
7) WEIGHT: 0.28 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE

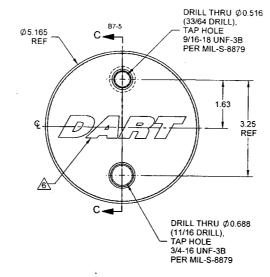
DESIGN	RF	DART AEROSPACE LTD	┪
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	-
CHECKED	15	DRAWING NO. REV. 8	Εl
MFG. APPR.	91	D3262 SHEET 4 OF	5
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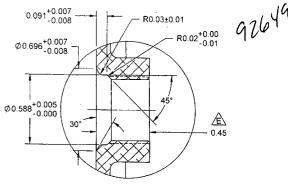
SECTION C-C D5-5



D3262-5 CAP

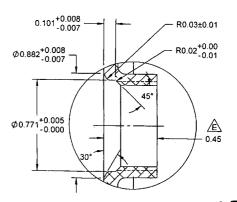


7) WEIGHT: 0.27 lbs 8) PART IS SYMMETRICAL ABOUT CENTERLINE



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DETAIL D C7-5



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DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	#5.	DRAWING NO. REV 6
MFG. APPR.	91	D3262 SHEET 5 OF
APPROVED	14	TITLE SCALE
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